

Date: Friday, 12/7/2007 10:20:52 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SADDLE, INBOARD, LS, 206
Job Number	36185			
Estimate Number	10820			
P.O. Number			Part Number	D26661
This Issue	12/7/2007	S.O. No. :	Drawing Number	D2666 REV. D
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	D
Previous Run	34859		Material	
Written By			Due Date	12/31/2007
Checked & Approved By		<i>07.12.07</i>	Qty:	12
Comment	Est: C	00.11.01	Removed P/O for Powder Coat - in house	Um: Each
		process EC		
		Est Rev:D As per Rev D 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)	
	7075-T7351 2X6X6.25	
	Issue material from stock:	
	Cut Size 2.0 x 6.25 X 6.0	
	Grain Along Long 6.0 Length	
	Batch No: <i>B34872 DSP 08/02/04</i>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1	
	Program batch number.	
	1-Inspect part number and batch number are programmed correctly.	
	2-Fixturing Inspection last completed on <i>36185</i> by <i>DSP</i>	
	3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	
	6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	
	8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	
	9- Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE	
	Machine Keyway and inspect per attached dimension sheet	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
		<i>DSP 08/02/04 / SF 08/02/05</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/02/08
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/7/2007 10:20:52 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 36185

Part Number: D26661

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 08/02/06

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



12X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M/L

08/02/06

7.0 POWDER COATING POWDER COATING



M/06379

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FJ 08/02/07 12

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



12X

Comment: INSPECT POWDER COAT

M/L

08/02/07

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST426

AS 08/02/07

12

10.0 QC21 FINAL INSPECTION/W/O RELEASE



12

Comment: FINAL INSPECTION/W/O RELEASE

AS 02/08

Job Completion



M 2008/12/07

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	36185
Description: 206 Saddle, Inboard, Left side				Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.137	.137	.137	.138		
B	0.100	0.140		0.127	.127	.127	.128		
C	2.470	2.510		2.494	.494	.494	.495		
D	0.100	0.180		0.140	.140	.140	.140		
E	0.210	0.230		0.220	.222	.225	.225		
F	1.313	1.343		1.325	1.325	1.325	1.328		
G	0.240	0.260		0.254	.254	.254	.254		
H	0.615	0.685		0.670	.670	.670	.670		
I	1.125	1.145		1.1415	.141	.142	.142		
J	0.990	1.010		1.008	1.008	1.006	1.006		
K	0.235	0.240		0.237	.237	.238	.239		
L	0.510	0.515		0.511	.511	.511	.511		
M	0.100	0.120		0.107	.107	.108	.108		
N	1.565	1.585		1.573	1.573	1.572	1.572		
O	5.990	6.010		6.0000	6.0000	6.002	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.499	2.500	2.500	2.500		
R	0.490	0.510		0.500	.500	.501	.501		
S	0.313	0.318		0.315	.318	.318	.318		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.3615	1.361	1.361	1.361		
V	0.315	0.322		0.320	.320	.322	.320		
W	0.540	0.560		0.554	.554	.555	.550		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		0.259	.259	.259	.259		
Z	0.178	0.198		0.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									

Accept/Reject

Measured by:	DSP	/JL	Audited by:	JL
Date:	08/02/04	/08/02/05	Date:	08/02/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DS1 9095, DS1 9102 & DS1 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD				Work Order:	36185
Description: 206 Saddle, Inboard, Left side				Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.135	.135	.135	.135		
B	0.100	0.140		.125	.127	.127	.127		
C	2.470	2.510		2.497	2.497	2.497	2.497		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.225	.225	.227	.225		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.240	0.260		.254	.254	.255	.255		
H	0.615	0.685		.670	.670	.670	.670		
I	1.125	1.145		.142	.142	.142	.142		
J	0.990	1.010		1.007	1.005	1.001	1.001		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.108	.108	.108	.108		
N	1.565	1.585		1.572	1.570	1.570	1.570		
O	5.990	6.010		6.006	6.005	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.501	2.501	2.500	2.500		
R	0.490	0.510		.502	.502	.502	.502		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.366	1.360	1.360	1.360		
V	0.315	0.322		.318	.318	.318	.318		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.670	1.670	1.670	1.670		
Y	0.257	0.262		.260	.260	.260	.260		
Z	0.178	0.198		.187	.187	.188	.187		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>RF</i>	Audited by:	<i>JL</i>
Date:	<i>08/02/06</i>	Date:	<i>08/02/06</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM <i>RF</i>	<i>JLM</i>

DART AEROSPACE LTD				Work Order:	36185
Description: 206 Saddle, Inboard, Left side				Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.135	.135	.135	.135		
B	0.100	0.140		.127	.127	.127	.126		
C	2.470	2.510		2.500	2.500	2.500	2.500		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.225	.225	.225	.225		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.240	0.260		.254	.254	.254	.255		
H	0.615	0.685		.670	.670	.670	.670		
I	1.125	1.145		.142	.142	.142	.142		
J	0.990	1.010		1.007	1.007	1.006	1.005		
K	0.235	0.240		.238	.238	.238	.238		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.108	.108	.108	.108		
N	1.565	1.585		1.570	1.570	1.570	1.570		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.502	.502	.502	.502		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.360	1.360	1.360	1.360		
V	0.315	0.322		.318	.318	.318	.318		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>JF</i>	Audited by:	<i>JL</i>
Date:	<i>08/02/06</i>	Date:	<i>08/02/06</i>

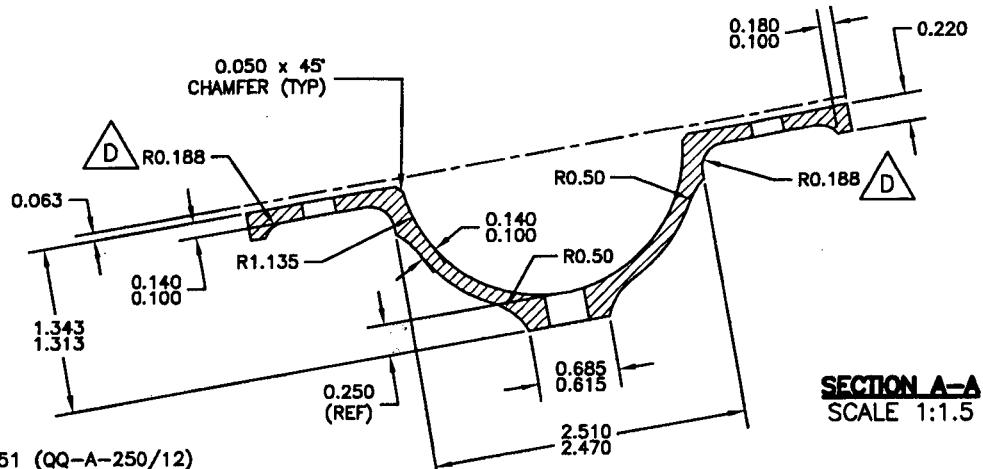
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
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E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM <i>JF</i> <i>JL</i>	

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2666 REV. D SHEET 1 OF 1
DATE		TITLE SCALE
06.11.08		SADDLE FWD INSIDE HIGH 1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313

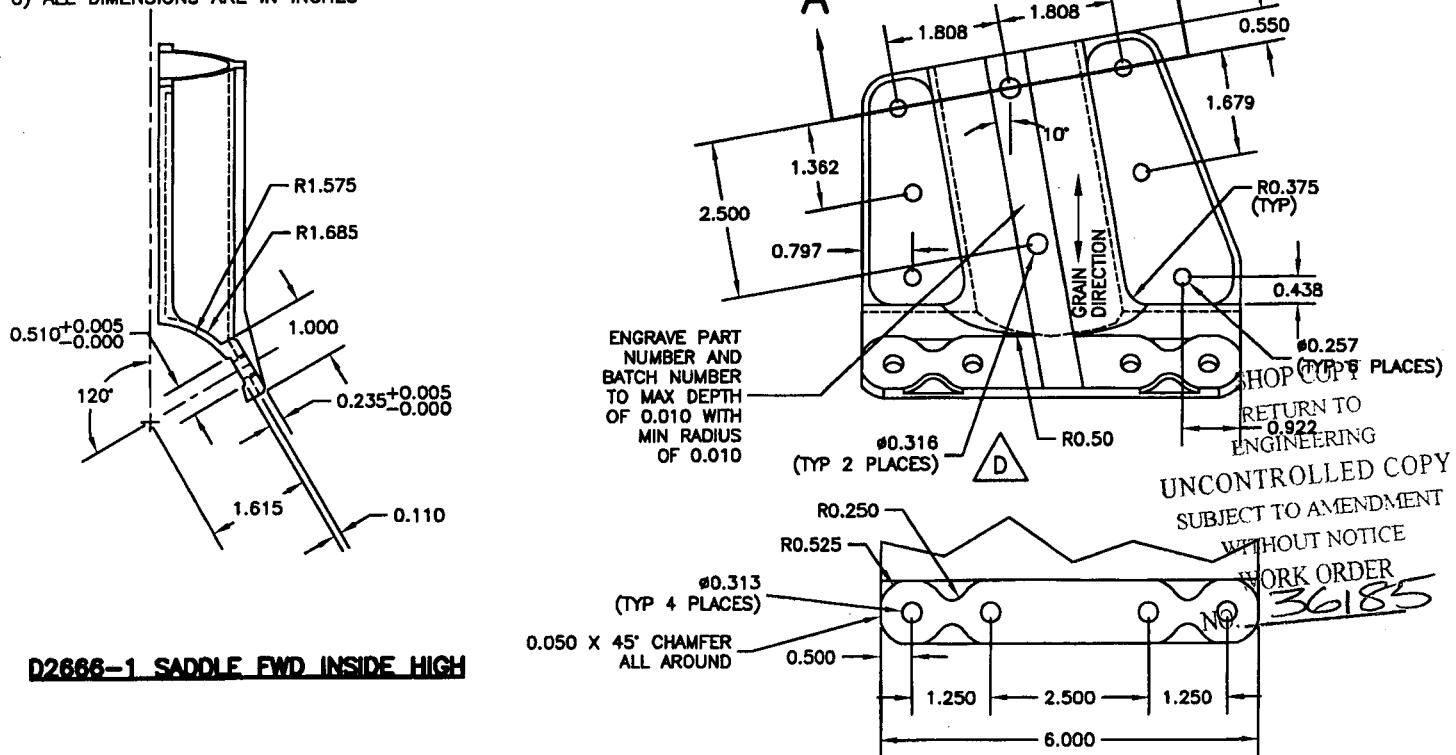
RELEASED

07.02.12



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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